Monday, 2/27/2006 4:17:50 PM

User:

Kim Johnston

**Process Sheet** 

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 25968

: 10271

**Estimate Number** P.O. Number

: NIA

This Issue

: 2/27/2006

: NC

: N/A : 25088

S.O. No. : N/A

Type

: MACHINED PARTS

**Part Number** 

Material

**Due Date** 

**Drawing Name** 

: D2561

: LUG

**Drawing Number** 

: D2561 REV B : N/A

**Project Number Drawing Revision** 

: B

: 3/20/2006

:NIA

42

Written By

Comment

Prsht Rev.

First Issue

**Previous Run** 

Checked & Approved By

: Est

00.05.19 Added inspect level 8 EC

Qty:

40- Um:

Each

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0250X06000



6061-T6 Bar .25" x 6.0"



Comment: Qty.:

0.3850 f(s)/Unit Total: 15.4014 f(s)

Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick Batch: M17869 = 139.2 inches

M17037=43.5 inches

21

2.0

BAND SAW



Comment: BAND SAW

BAND SAW

1-Cut blanks: 8.70"

Note: 1 blank makes 2 parts

HAAS CNC VERTICAL MACHINING #1

3.0

HAAS1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2561

2-Debuil, no sharp-edges sent to oak

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06.03.01 42

## **Dart Aerospace Ltd**

W/O:			WORK ORDER	CHANGES		•		
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		÷						
Part No	:	PAR #:	Fault Category:	NCR: Ye	es No DQ	A: 😂	Date: <	06/03/09
				QA	: N/C Close	d:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	Annroval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Monday, 2/27/2006 4:17:50 PM Date: User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: LUG** Job Number: 25968 Part Number: D2561 Job Number: Seq. #: Description: **Machine Or Operation:** SECOND CHECK 5.0 QC8 42 Comment: SECOND CHECK 6.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr, no sharp edges PACKAGING RESOURCE 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: t 8.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

## **Dart Aerospace Ltd**

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W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PROC	PROCEDURE CHANGE By Date Qty							Approval QC Inspector
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							Many Miles			
Part No	:	PAR #:	_ Fault Cateç	gory:	NCR	: Yes I	No <b>DQ</b> A	<b>\:</b>	Date:	
	•					QA: N/	C Closed	l:	_ Date: _	
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE	(NCR)	)			
DATE	STEP	Description of NC	Corrective Action Section B				Verification	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	`	Sign & Date	Section		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25968
Description: Lug Plate	Part Number:	D2561
Inspection Dwg: D2561 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	-502				
2.025	+/-0.010	2.024	//			
3.975	+/-0.010	3.974				
Ø0.257	+0.005/-0.000	259	/			
4.025	+/-0.010	4.024				
5.025	+/-0.010	5-024	1			
0.25	+/-0.030	.246				
		,				
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Measured by: JL	Audited by:	The	Prototype Approval:	N/A
Date: 06.03.01	Date:	06/03/01	Date:	NIA

A 04.01.21 New Issue KJ/RF	Rev	Date	Change		Revised by	Approved
	Α	04.01.21	New Issue	4	KJ/RF	



1	DESIGN	DRAWN BY	DART AEROSPACE			
	R WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT,	CANADA		
	CHECKED	APPROVED	DRAWING NO.		REV.	. 8
	Br.	608	D2561	SHEET		F 1
	DATE	1	TITLE		SC/	¥LE
	96.04.26		LUG PLATE			1:1

